

SHOP PRESS ASSEMBLY INSTRUCTIONS

212025 - 25 TON MANUAL SHOP PRESS

PRESS SPECIFICATIONS

LEVEL	MODEL #	CAPACITY (TONS)	RAM TRAVEL (IN.)	THROAT HEIGHT (IN.)		THROAT WIDTH (IN.)	BED WEIGHT ADJUSTMENTS (IN.)		BETWEEN BED RAILS (IN.)	BASE (IN.)		OVERALL HEIGHT (IN.)	SHIPPING WEIGHT (LBS.)
				MIN.	MAX.		QTY.	IN.		WIDTH	DEPTH		
1	212025	25	6.125	.5	33.5	35	8	5	8	42	29.75	74	513

SAFETY INFORMATION

WARNING

This symbol alerts you to the possibility of serious injury or death if instructions are not followed.

CAUTION

This symbol alerts you to the possibility of damage to or destruction of equipment if instructions are not followed.

WARNING

Failure to heed these warnings may result in loss of load, damage to the press and/or failure resulting in property damage, personal or fatal injury. This operating manual contains important details concerning the safe operation of this tool. The user must read and understand these details before any use of the tool. This manual must be retained for future reference.

- Read, study, understand and follow all instructions before operating this device.
- Do not exceed rated capacity.
- Prior to use make sure press is securely anchored.
- This press shall be installed and operated in accordance with federal (OSHA), state, and local safety standards.
- Operators and observers shall wear eye protection and personal protective equipment (PPE) that meets ANSI Z87.1 and OSHA standards.
- Keep hands, arms, feet, legs etc. out of work area. Accidental slippage can result in personal injury.
- Use appropriate guarding that complies with local, state and federal regulations to contain any pieces that may break or fly apart when applying force.
- Use only press accessories having a capacity rating equal to or greater than the capacity of the press.
- Verify lift cables are slack before pressing on the bolster.
- Before applying load, be certain all press bed supporting pins are fully engaged.
- Avoid off-center loads.
- Do not substitute parts or make any alterations to this press. Use only genuine AmerEquip replacement parts and accessories.
- Always center load on ram plunger. Offset loads can damage ram and may cause load to eject at a dangerous rate of speed.
- Remove all loads from press bed before attempting to adjust bed height.
- This product contains one or more chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. *Wash hands thoroughly after handling.*
- Failure to heed these warnings may result in serious or fatal personal injury and/or property damage.

OWNER/USER RESPONSIBILITY

The owner and/or user must have an understanding of the manufacturer's operating instructions and warnings before using this press. Personnel involved in the use and operation of equipment must be careful, competent, trained, and qualified in the safe operation of the equipment and its proper use. Warning information should be emphasized and understood.

If the operator is not fluent in English, the manufacturer's instructions and warnings must be read to and discussed with the operator in the operator's native language by the purchaser/owner, making sure that the operator comprehends its contents.

Owner and/or user must study and maintain for future reference the manufacturer's instructions. Owner and/or user is responsible for keeping all warning labels and instruction manuals legible and intact. Replacement labels and literature are available from the manufacturers.

INSPECTION

Visual inspection of the shop press should be made before each use of the press, checking for damaged, loose or missing parts. Each press must be inspected by a manufacturer's repair facility immediately if subjected to an abnormal load or shock. Any press which appears to be damaged in any way, is found to be badly worn, or operates abnormally must be removed from

service until necessary repairs are made by a manufacturer's authorized repair facility. It is recommended that an annual inspection of the press be made by a manufacturer's authorized repair facility and that any defective parts, decals or warning labels be replaced with manufacturer's specified parts. A list of authorized repair facilities is available from the manufacturer.

SAFETY INSTRUCTIONS

- CHECK YOUR LOCAL, STATE AND FEDERAL REGULATIONS REGARDING THE SAFE USE OF THIS EQUIPMENT.
- Your safety is a top priority. Please handle equipment with care.
- Fully retract unit and remove all items from the press bed frame.
- Support the press bed and remove the pins.
- Raise or lower bed to desired height and reinstall press pins. Be certain pins are fully engaged in the parallel flanges of the upright columns.
- Position press on a flat, level, hard surface, preferably concrete. Make sure all nuts and bolts are tight.
- Clear the area of bystanders, especially small children, before using.
- Set the press bed to the required height. The press is most effective when the work piece is located 1 inch below the ram's retracted position. The compression stroke can include the entire 5 inch working range.
- The press is designed to exert a force on anything which is positioned beneath its ram. The work piece can be ejected from under the ram at a high rate of speed and can injure someone.
- Pressing Bearings: It is essential that you use the bearing shield when pressing bearings on or off.

OPERATION

1. **STOP – Before operating, turn petcock valve (breather) on top of the pump counterclockwise to open.**
2. Press beds are adjustable up and down to fully take advantage of available ram travel and numerous work pieces.
3. Slowly open release valve on power unit. With the power unit in its stored position, remove all items from the press bed.
4. Be sure press bed is supported properly and remove press bed pins.
5. Raise or lower press bed to desired height, and reinstall press bed pins. Be certain pins are completely through both sides of frame, as these pins are the major support mechanism for the bed.

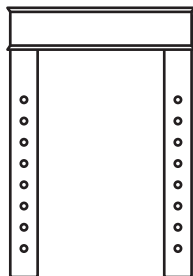
We want to know if you have any problems with our products.

If you are missing any parts or find any damage, call AmerEquip directly at 1-(800) 684-0277. Please do not call the store where you purchased this product.

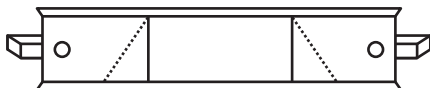
PARTS LIST

ESTIMATED ASSEMBLY TIME: 45 MINUTES

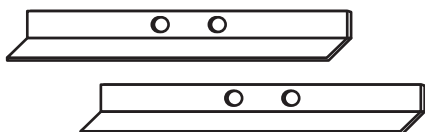
Press Frame - 1



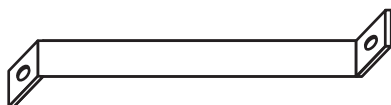
Press Bed - 1



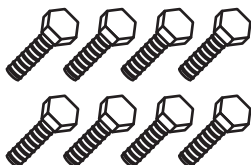
Press Feet - 2



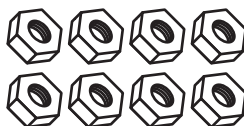
Z Bar - 1



1/2"-13 x 1-1/2"
Hex Head Bolts - 8



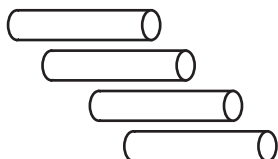
1/2" Nuts - 8



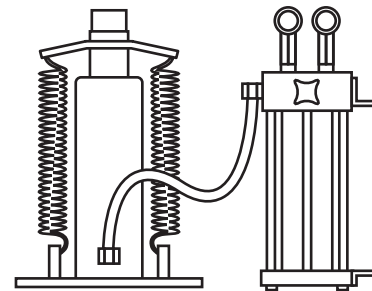
Washers - 8



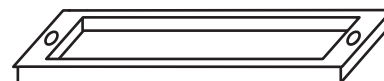
1-1/4" x 14"
Press Pins - 4



Two Stage
Pump and Ram - 1



Ram Frame - 1

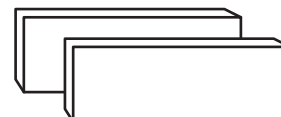


Pump Extension Handle - 1



ACCESSORIES

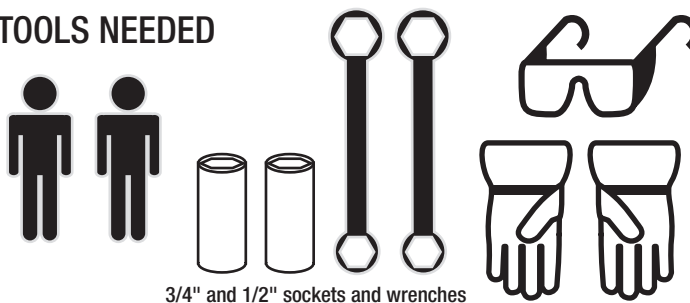
1" x 3" x 14"
Press Plates - 2
*Accessory only -
Not needed for assembly*



Pushing Adapter - 1
*Accessory only -
Not needed for assembly*



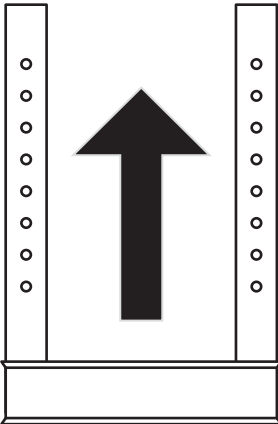
TOOLS NEEDED



Examine box contents, then proceed with the following instructions.

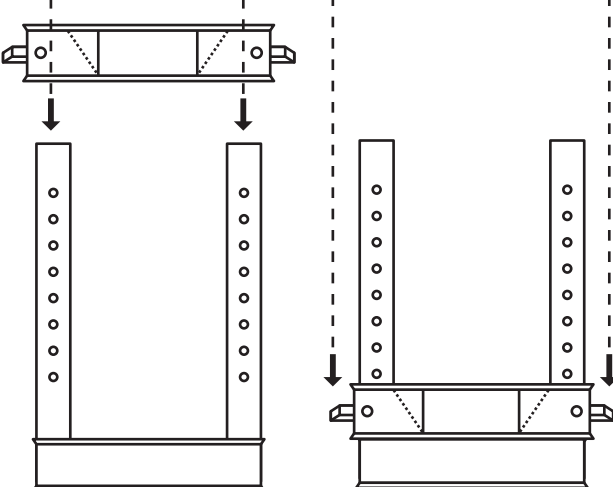
ASSEMBLY INSTRUCTIONS

1



Stand frame upside down

2

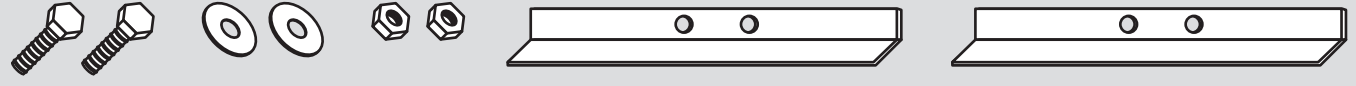
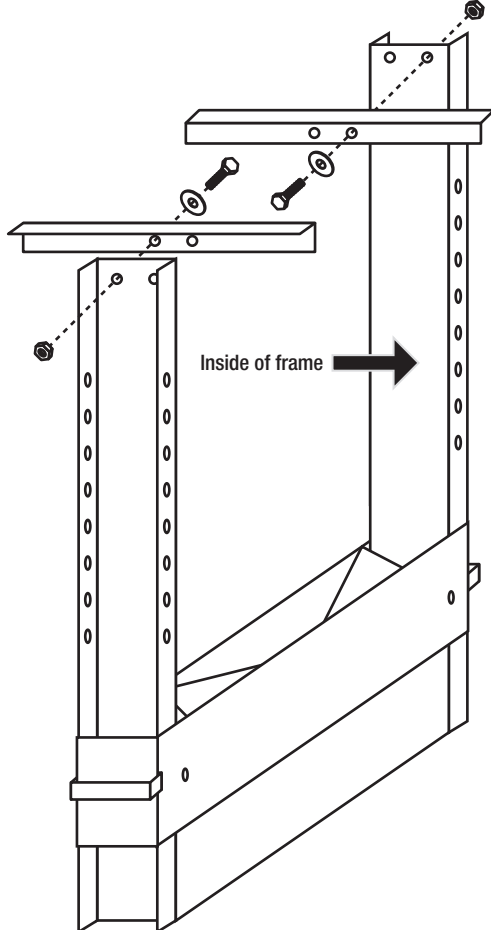


Slide bed onto frame

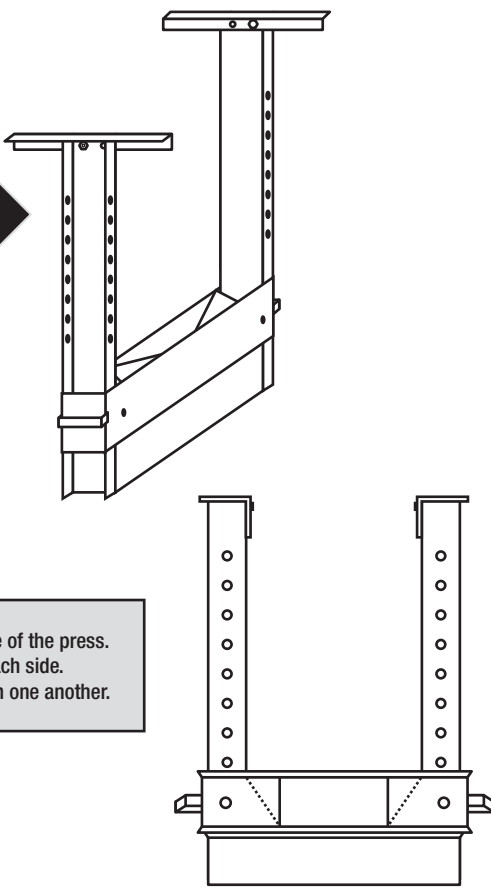
Slide bed down to bottom of frame

Note: In the upright position, inner bracing should form an inverted "v" with the narrower space facing the top of the press.

3

Inside of frame

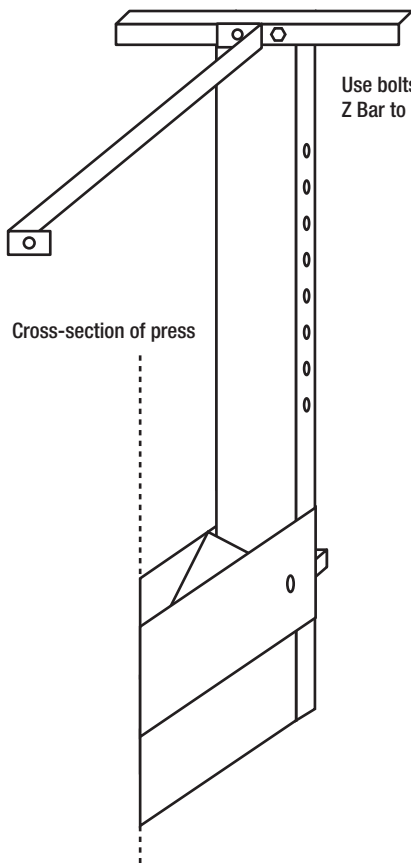
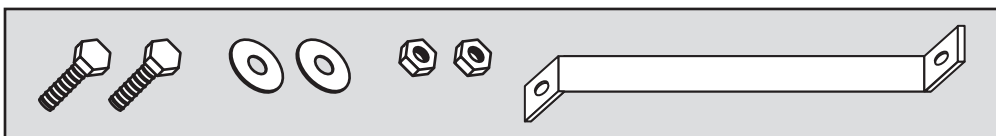


Front view

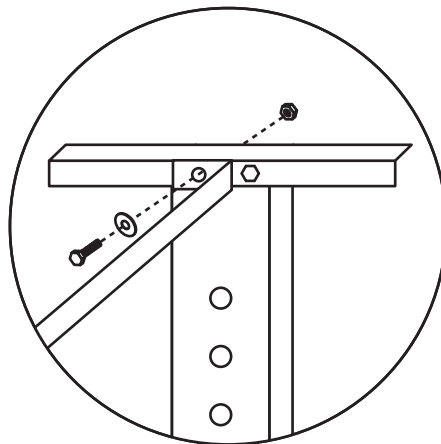
Note: Position press feet on each side of the press. Attach one bolt, washer and nut on each side. Bolts should be attached *OFFSET* from one another.

ASSEMBLY INSTRUCTIONS CONTINUED

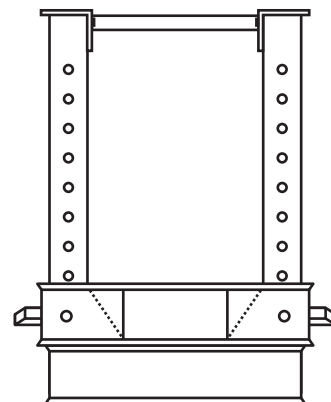
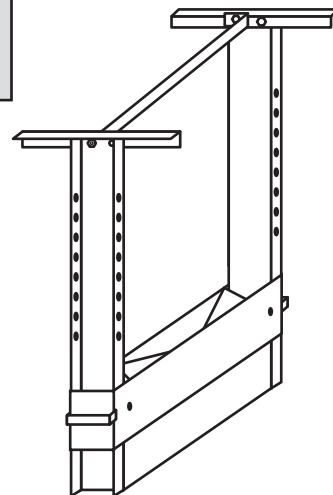
4



Use bolts, washers and nuts to attach Z Bar to both sides of the press.



Note: Check all bolts for tightness. If press rocks, or is not level, loosen press feet slightly to compensate and retighten.



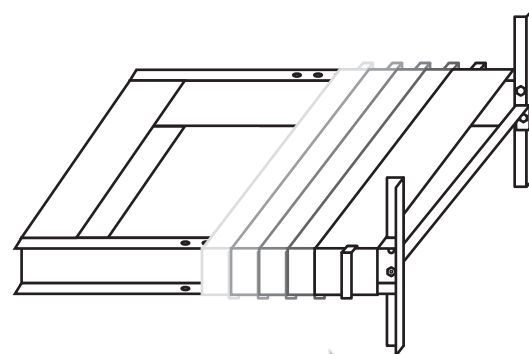
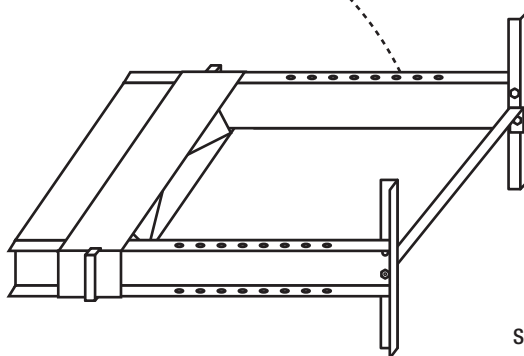
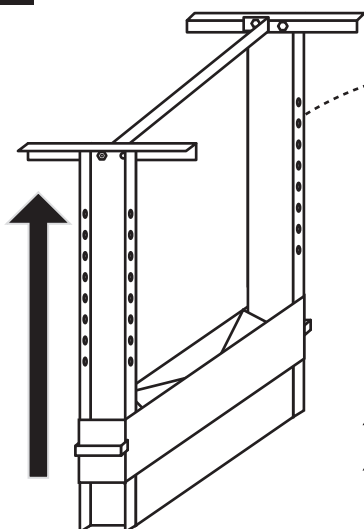
Front view

5

⚠ WARNING

Bed must be at the **BOTTOM** of the frame before proceeding to the next step.

Note: When sliding bed to frame bottom, DO NOT use bed handles.



Slide bed down to bottom of frame



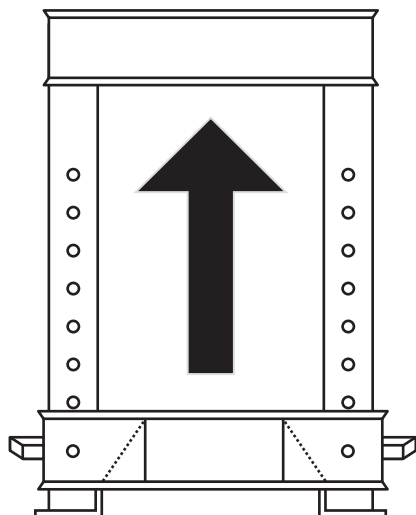
ASSEMBLY INSTRUCTIONS CONTINUED

6

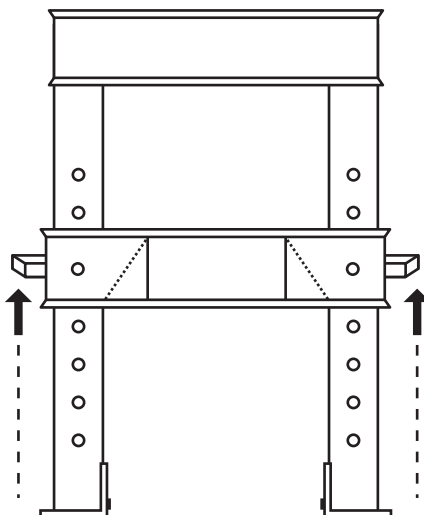


WARNING

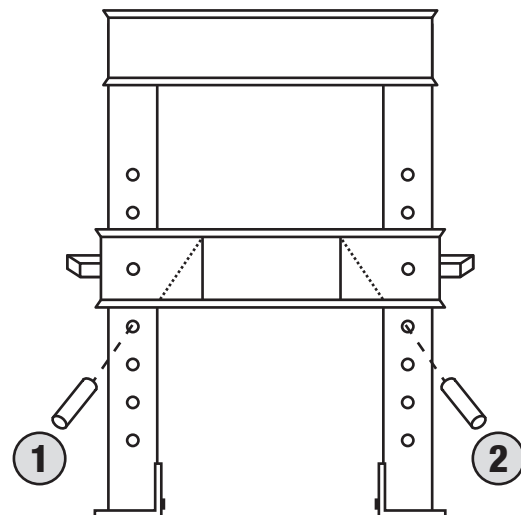
Pins must be COMPLETELY through BOTH SIDES of frame.



Stand unit upright



Slide bed above holes and *hold in place*



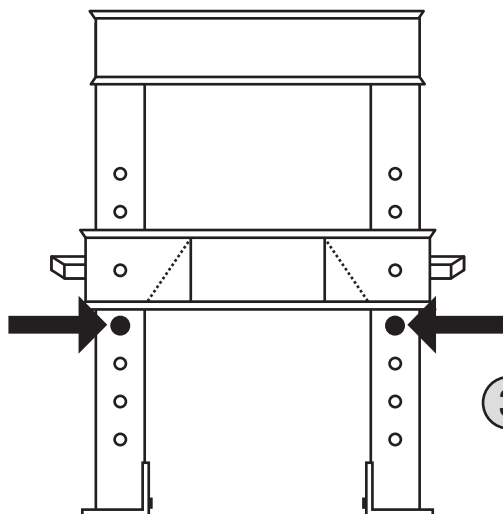
Secure pins underneath bed, one at a time

7

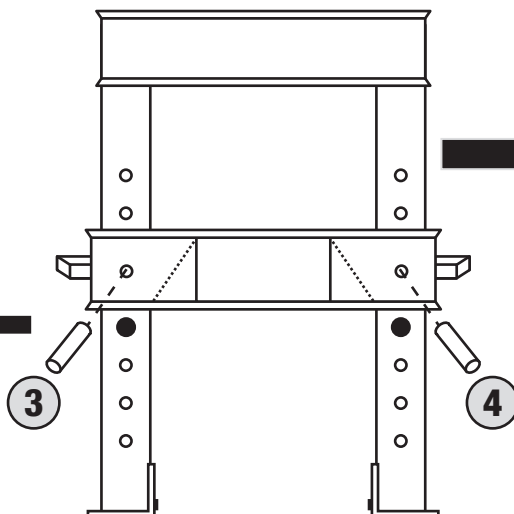


WARNING

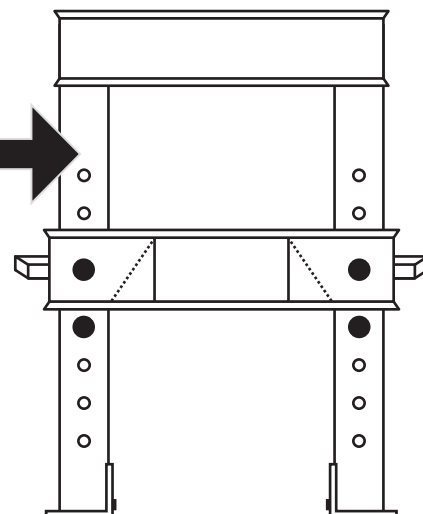
ALL FOUR (4) pins must be COMPLETELY through BOTH SIDES of frame in order to operate press.



Let bed rest on inserted pins



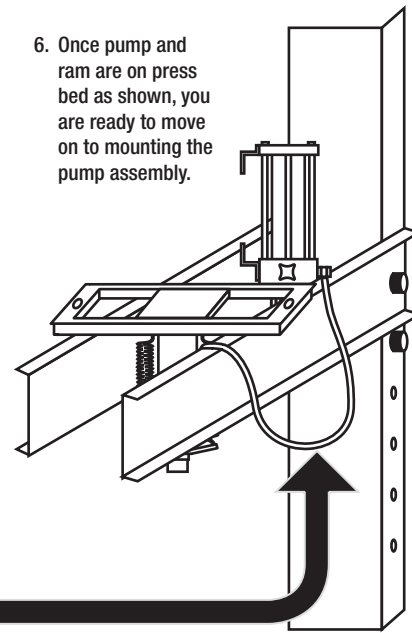
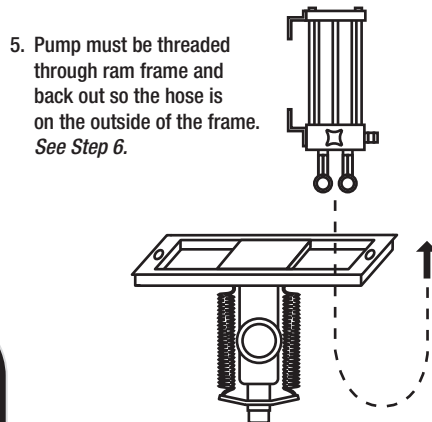
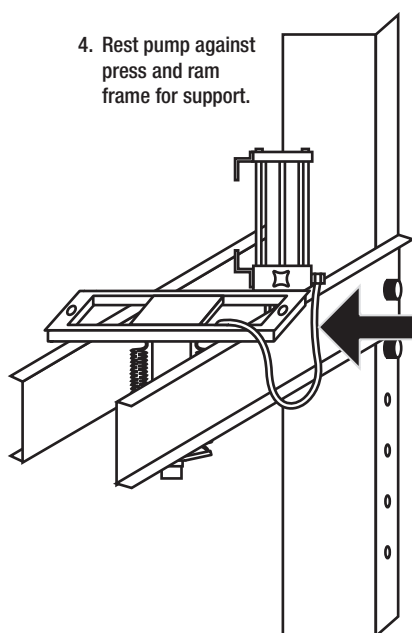
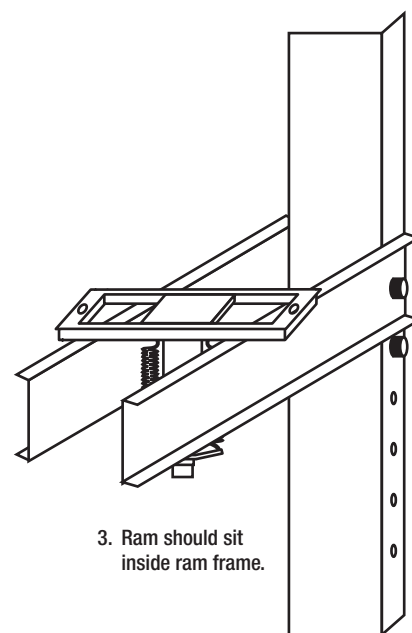
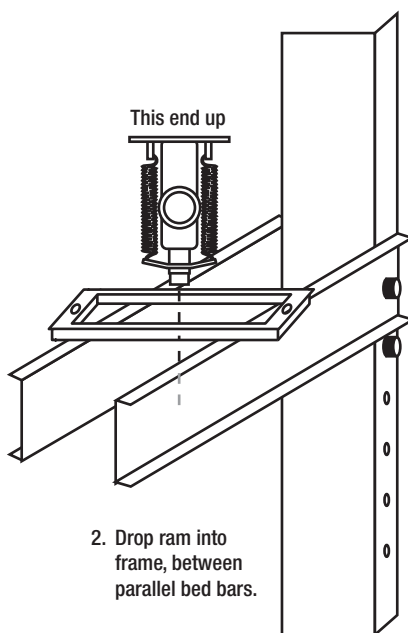
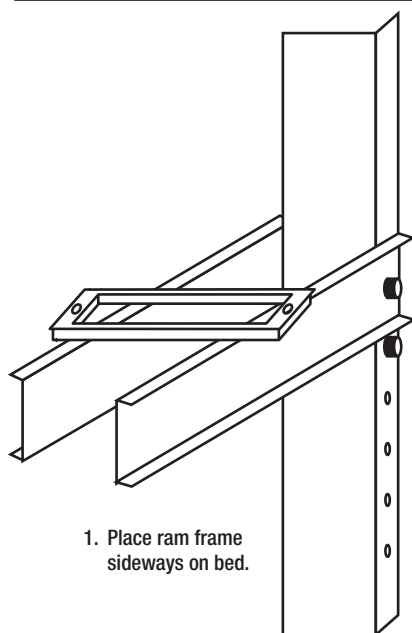
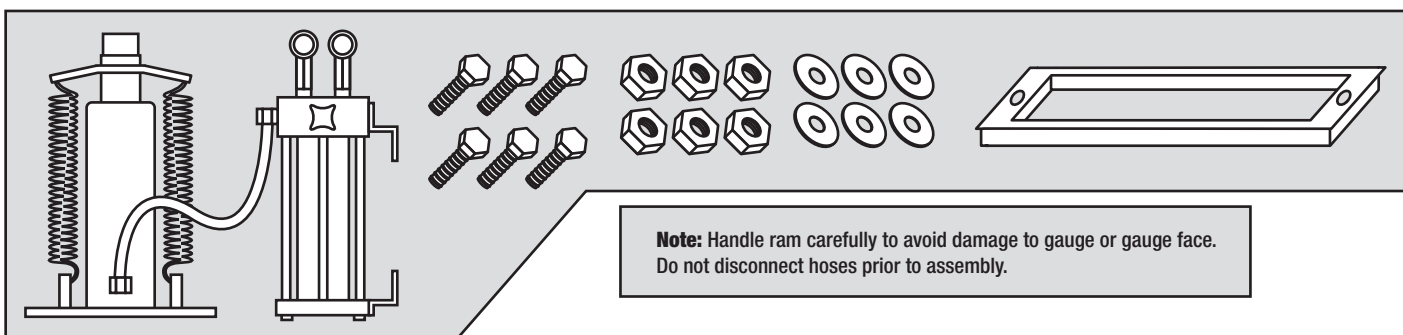
Place 3rd and 4th pin on each side



Secure pins completely through bed and frame.

RAM FRAME ASSEMBLY INSTRUCTIONS

8

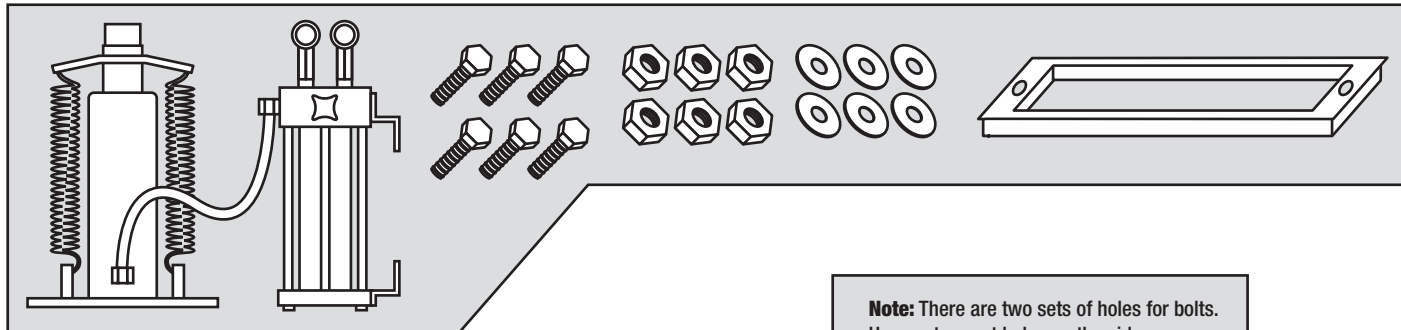


⚠ WARNING

Hose must be on the OUTSIDE of ram frame, or it will NOT be mountable to the press.

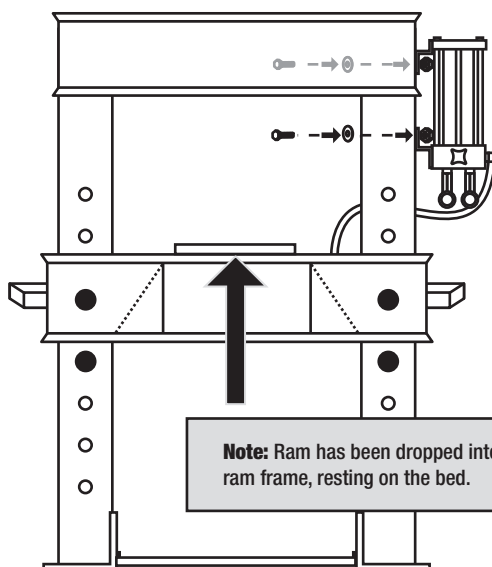
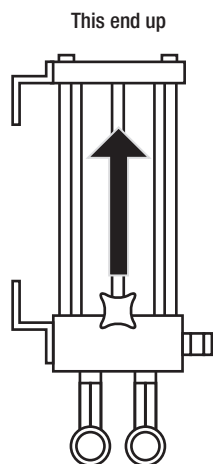
PUMP AND RAM ASSEMBLY INSTRUCTIONS

9



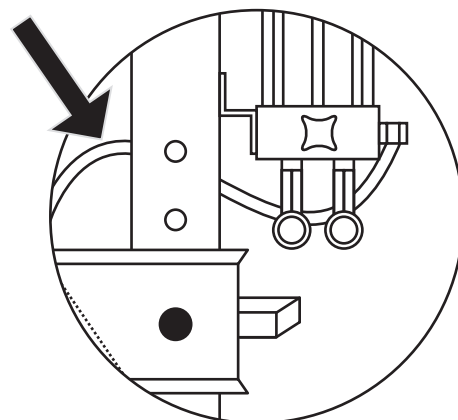
Note: There are two sets of holes for bolts. Use centermost holes on the side.

A

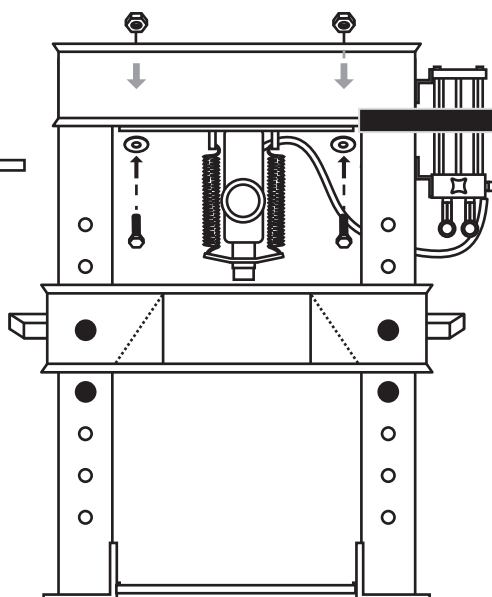
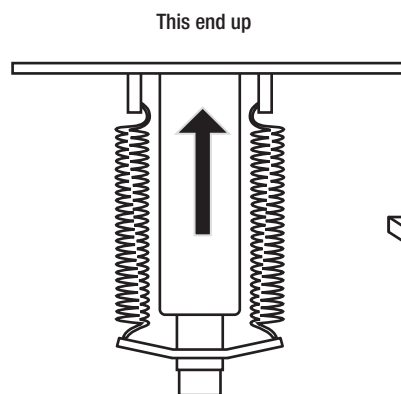


Note: Ram has been dropped into ram frame, resting on the bed.

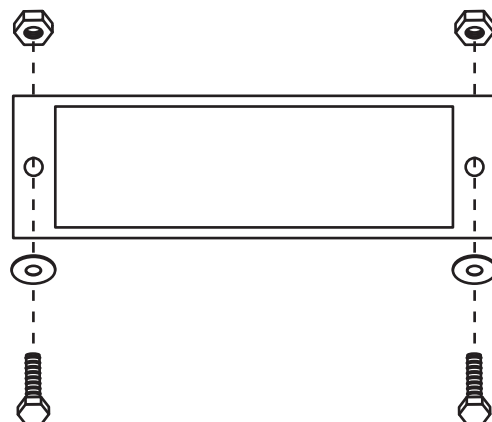
Note: Hose must run BEHIND frame. DO NOT disconnect hose from pump or ram.



B



Attach bolts up through ram frame to matching holes in press. Hand tighten. Wrench tighten after both bolts have been installed. Ram is now able to slide left and right within ram frame.

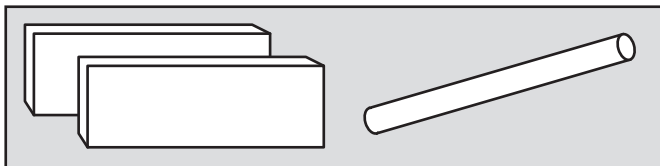


⚠ WARNING

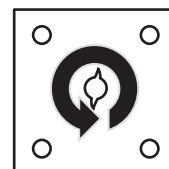
DO NOT attempt to operate pump unless the **BREATHER VALVE IS OPEN**. Valve is closed prior to shipping to prevent the loss of hydraulic fluid.

PROCEDURE FOR BLEEDING AIR

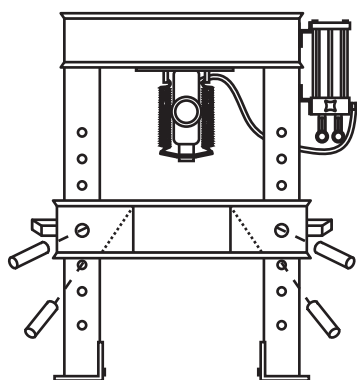
10



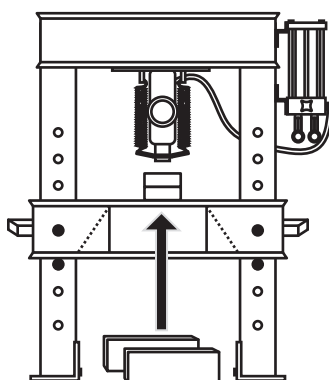
1. Turn valve handle on **FRONT** of pump **CLOCKWISE** until closed. **DO NOT OVERTIGHTEN.**



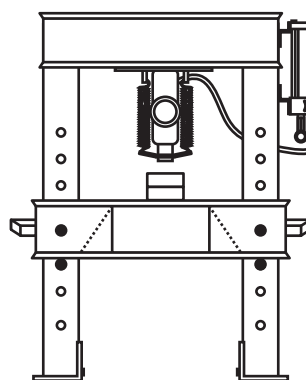
2. Turn petcock valve (breather) on **TOP** of pump **COUNTERCLOCKWISE** to open.



3. Move press bed into highest position and lock bed into place with both pins.



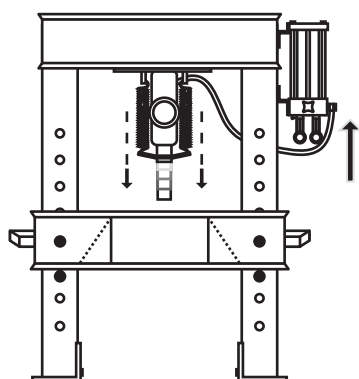
4. Place press plates **DIRECTLY** under ram, on press bed.



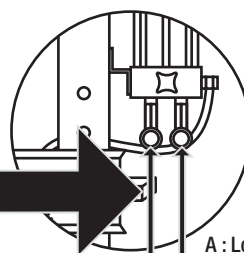
5. Put cradle in the **DOWN** position. Use an adapter on your air hose and allow air to flow through the opening in the petcock valve into the pump.

⚠ CAUTION

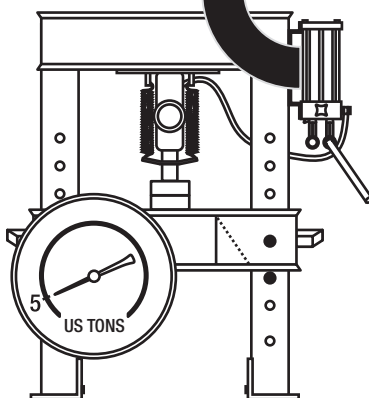
Bed must be in **UP** position, or you will over extend ram.



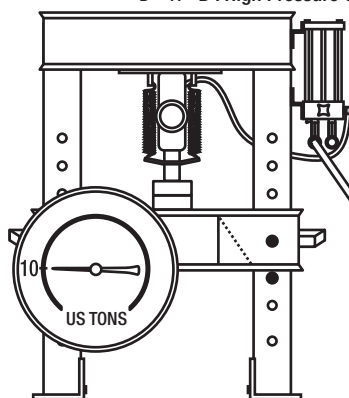
6. Air that has flowed into the pump causes the cradle to move up and the ram to move down. If this happens, proceed to step 7. If not, check all hoses and connections and repeat the procedure.



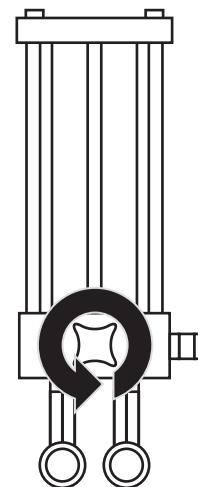
A : Low Pressure Cradle
B : High Pressure Cradle



7. Insert pump handle into **LOW PRESSURE CRADLE**. Pump ram against press plates until gauge reads "5 Tons".



8. Insert pump handle into **HIGH PRESSURE CRADLE**. Pump ram against press plates until gauge reads "10 Tons".



9. Turn valve handle on pump **COUNTERCLOCKWISE** a maximum of one (1) turn to open valve. Ram will retract as pressure is released.

⚠ WARNING

Do not allow the ram to extend more than 5.5".

PUMP INSTRUCTIONS

11

⚠ WARNING

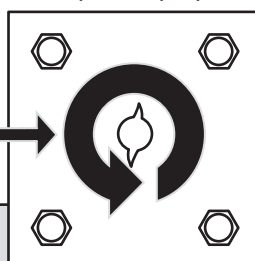
This symbol alerts you to the possibility of serious injury or death if instructions are not followed.

Failure to heed these warnings may result in loss of load, damage to the press and/or failure resulting in property damage, personal or fatal injury. This operating manual contains important details concerning the safe operation of this tool. The user must read and understand these details before any use of the tool.

This manual must be retained for future reference.

1. BEFORE OPERATING PUMP, open petcock valve (breather) located on TOP of pump assembly by turning COUNTERCLOCKWISE.

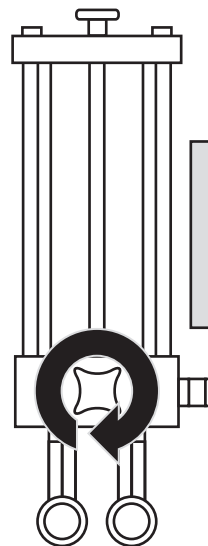
Top view of pump



⚠ WARNING

DO NOT attempt to operate pump unless the BREATHER VALVE IS OPEN. Valve is closed prior to shipping to prevent the loss of hydraulic fluid.

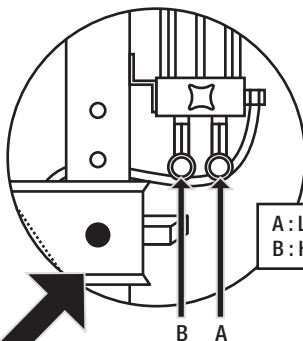
2. CLOSE the valve located on the FRONT of the pump assembly by turning CLOCKWISE.



⚠ CAUTION

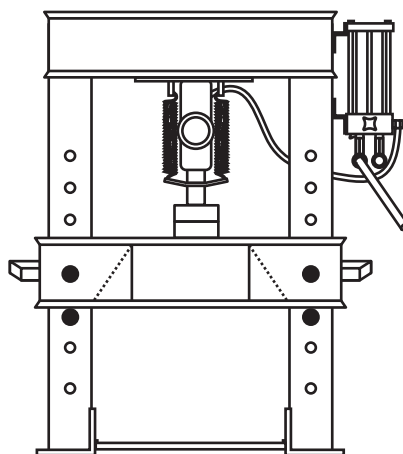
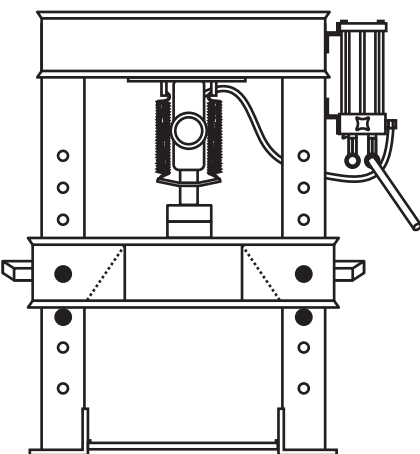
HAND TIGHTEN VALVE ONLY. Excess pressure could damage the valve assembly.

3. Insert pump handle into low pressure cradle. Use the low pressure pump until ram comes into contact with item to be pressed.

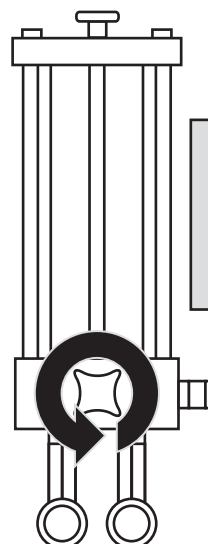


A : Low Pressure Cradle
B : High Pressure Cradle

4. Once ram is in contact with the item to be pressed, insert pump handle into high pressure side. Using the high pressure pump moves the ram less with each stroke and requires less effort to apply pressure.



5. To relieve pressure and retract ram, turn valve located on FRONT of pump assembly ONE FULL TURN COUNTERCLOCKWISE.

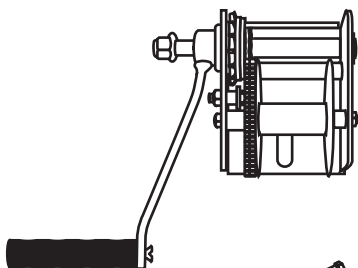


⚠ CAUTION

DO NOT TURN RELEASE VALVE MORE THAN ONE FULL TURN or equipment may be disabled.

WINCH KIT PARTS LIST

Winch - 1



Cable Clamp - 1



Long Cable - 1



3/8"-16 x 1-1/2"
Hex Head Bolts - 2



Short Cable- 1



3/8" Nuts - 2



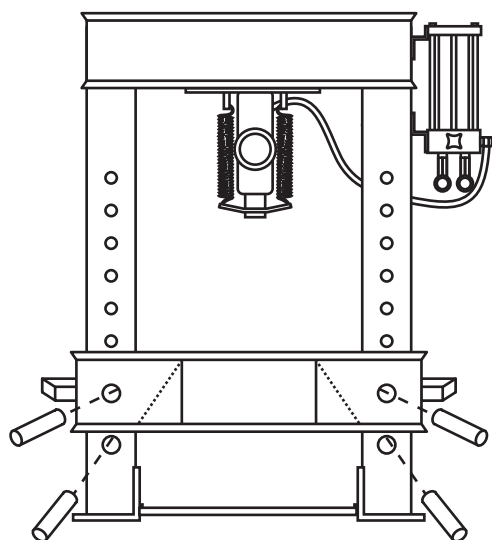
Washers - 2



WINCH INSTALLATION INSTRUCTIONS

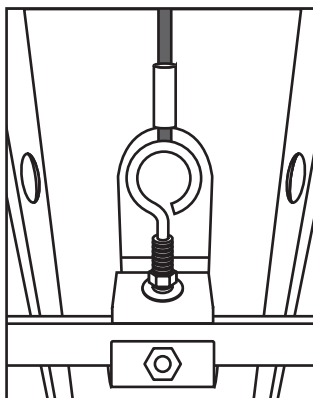
12

- Dark Gray- Long Cable
- Light Gray- Short Cable



1. Move press bed into LOWEST position so it is resting on top of pins 1 and 2.

Right side of press,
under pump assembly

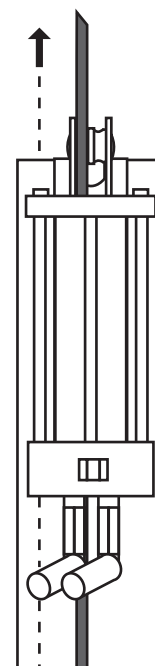


2. Install pre-attached eye bolt on LONGER cable to press bed handle located *under pump assembly*. DO NOT FULLY TIGHTEN. Center with side of press bed and make sure there is enough room to lower or raise both nuts on eye bolt for precise alignment.

⚠ WARNING

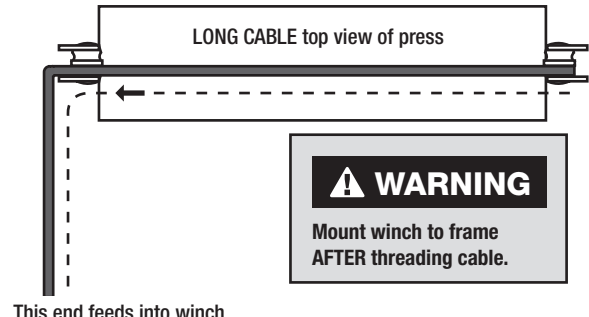
DO NOT FULLY TIGHTEN.

Right side of press



3. Thread the BARE end of the LONGER of the two steel cables up and through the pump bracket.

WINCH INSTALLATION INSTRUCTIONS

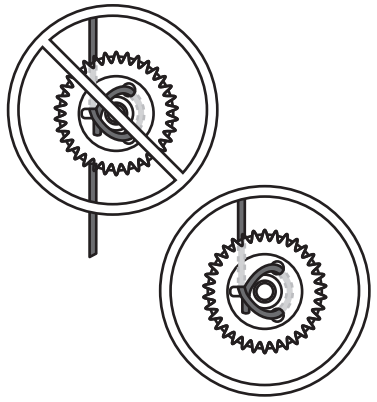


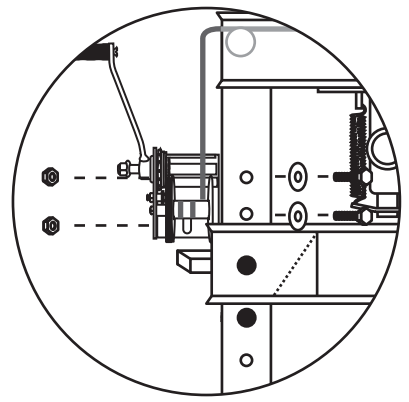
LONG CABLE top view of press

⚠ WARNING

Mount winch to frame
AFTER threading cable.

This end feeds into winch.

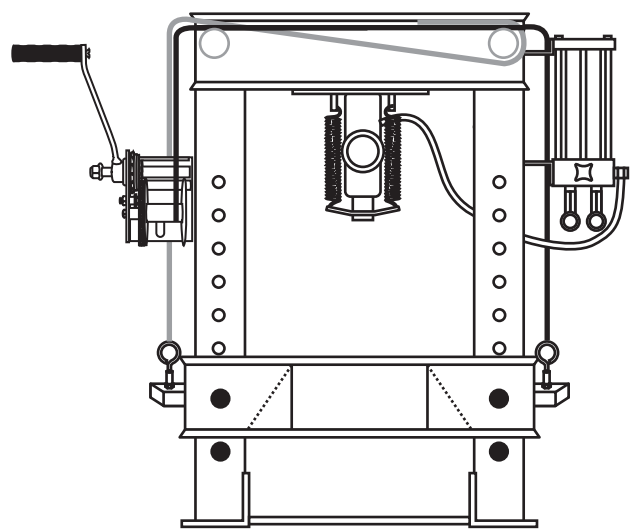




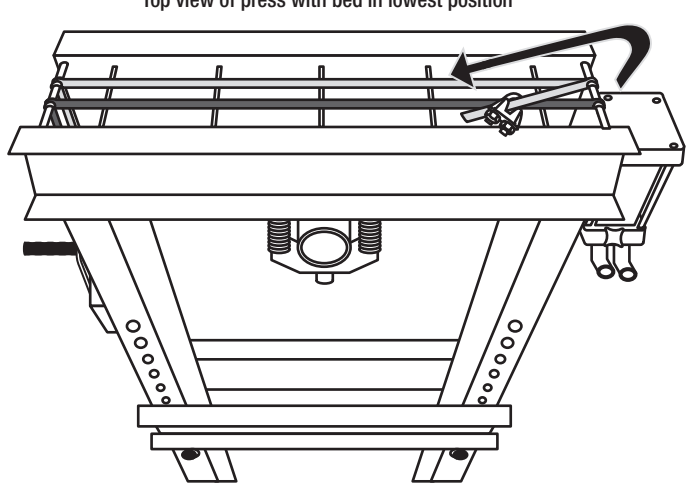
4. Run the long cable up and OVER BOTH ROLLER BRACKETS and feed into winch. Be sure to thread 12 inches (1 foot) of extra cable through winch.

5. Once winch cable has been threaded, pull excess cable back through winch as shown in diagram above. The cable should be locked tightly around itself with no excess cable left hanging. Operate winch enough to remove slack from longer cable.

6. Mount winch to frame using the provided washers, 1/2" nuts and 1/2"-13 x 1-1/2" bolts.

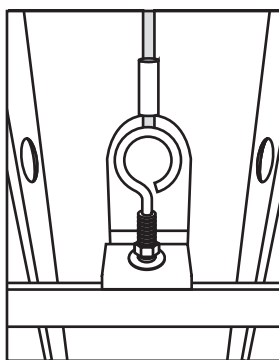


Top view of press with bed in lowest position



7. Feed the short cable by running it up and OVER first roller, then UNDER second roller. Loop the short cable back toward the winch and securely attach to the longer cable using the cable clamp. Remove slack from short cable before securing to long cable. Clamp should be NO LESS THAN ONE INCH (1") from roller.

Left side of press, under winch



8. Install pre-attached eye bolt on SHORTER cable to press bed handle located under winch *after feeding it around in step 7.*

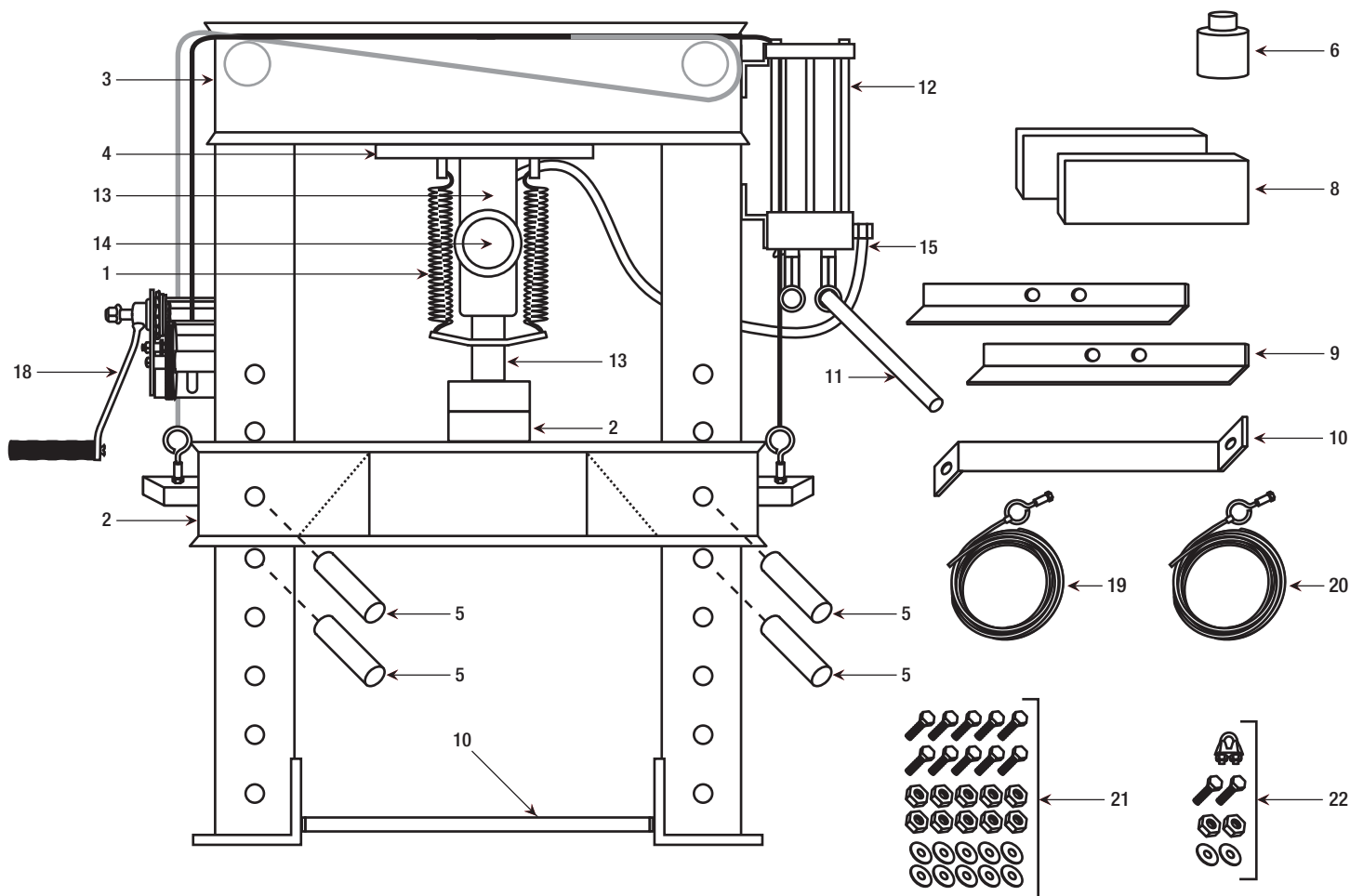
9. Turn eye hooks to adjust and level press bed. Once bed is level, firmly tighten eye hook mounting hardware. The steel cable will stretch with use. It may be necessary to repeat this leveling procedure in the future.

10. Test the winch kit by raising and lowering the press bed from its lowest to highest position. Repeat and adjust until bed is level and moves freely throughout its entire range of motion. Cut excess cable when all adjustments are complete.

We want to know if you have any problems with our products. If you are missing any parts or find any damage, call AmerEquip directly at 1-(800) 684-0277. Please do not call the store where you purchased this product.

REPLACEMENT PARTS LIST

212025 - 25 TON MANUAL SHOP PRESS



ITEM NO.		DESCRIPTION	QTY.	ITEM NO.		DESCRIPTION	QTY.
1		Press Spring	2	15		Hose & Fitting	1
2	†	Press Bed	1	17		Seal Kit for Pump and Ram (not shown)	1
3	†	Press Frame	1	18		Winch	1
4	†	Ram Frame	1	19		Short Cable (includes eye bolt)	1
5		Press Pin	4	20		Long Cable	1
6		Pushing Adapter	1	21		Press Hardware Kit	1 set
8		Press Plate	2			1/2"-13 x 1-1/2" Hex Head Bolt	10
9		Press Feet	2			1/2" Nut	10
10		Z Bar	1			Washer	10
11		Pump Handle	1	22		Winch Hardware Kit	1 set
12		Pump (includes handle)	1			Cable Clamp	1
13		Ram	1			3/8"-16 x 1-1/2" Hex Head Bolt	2
14		Gauge	1			3/8" Nut	2
						Washer	2

Items identified with a cross (†) are not available separately.

PUMP AND RAM EXPLODED PARTS DIAGRAM

See Replacement Parts List for parts available separately.

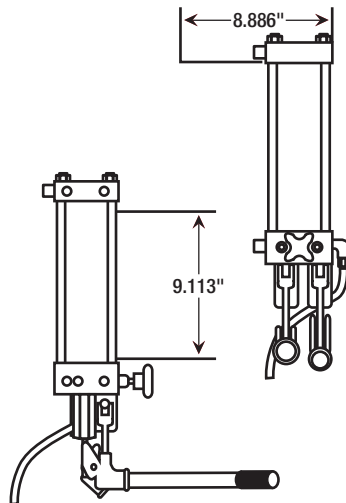
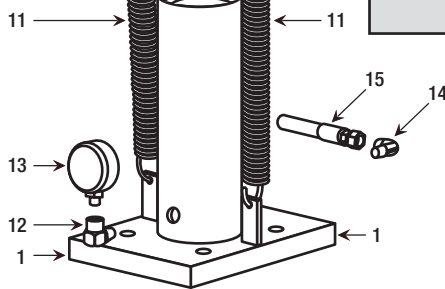
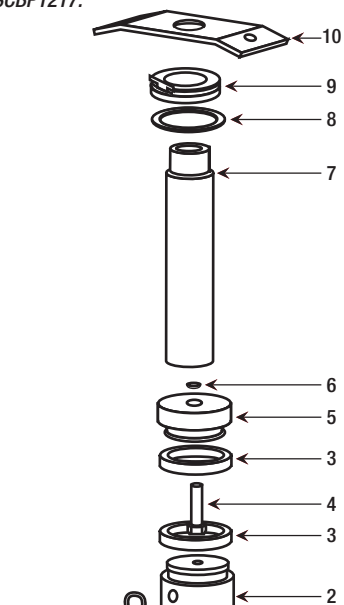
Parts with () are only available in Seal Kit, part number RSCBP1217.*

RAM

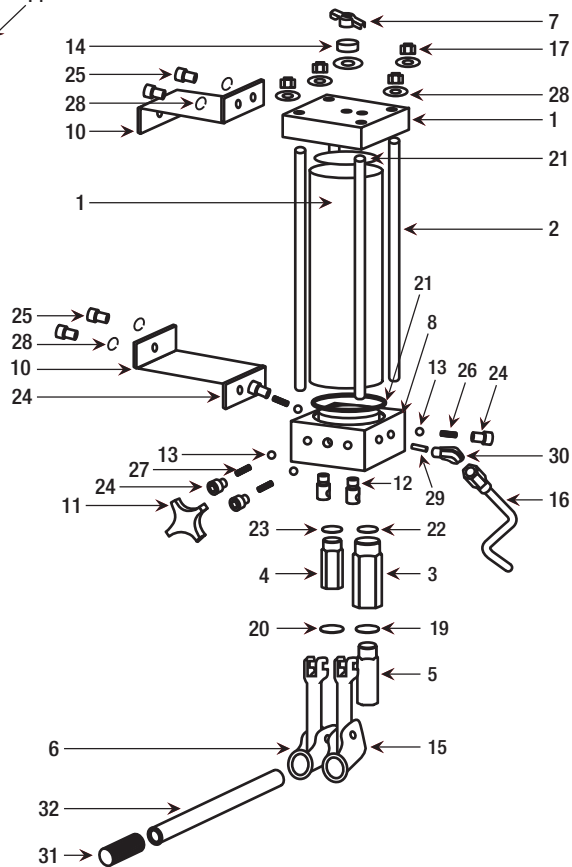
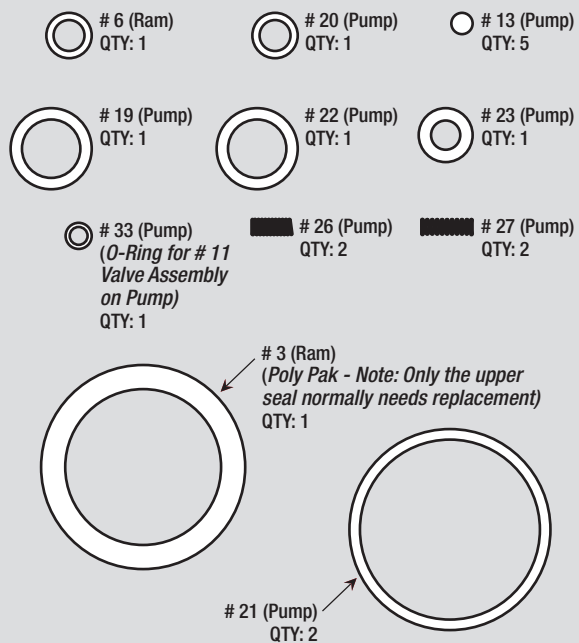
ITEM NO.	DESCRIPTION	QTY.
1	Base Weldment	1
2	Plug	1
3	* Polypak Seal (Parker)	2
4	1/2-13 x 2 Hex HD C-S GR 2 Zinc	1
5	Piston	1
6	* O-Ring (Parker)	1
7	Rod	1
8	Retaining Ring Int. 3.5 NOM	1
9	Piston Guide	1
10	Retractor Plate	1
11	Spring	2
12	Fitting Gauge 1.75	1
13	Gauge	1
14	90° Elbow 1/4 NPTF to -6 JIC	1
15	Hose Hydraulic 41 1/2 LG 7/16-20 JICF	1

PUMP

ITEM NO.	DESCRIPTION	QTY.
1	Tank	1
2	Tie Rod	4
3	1" Piston Body	1
4	1/2" Piston Body	1
5	1" Piston	1
6	1/2" Piston	1
7	1/4" MNPT Pressure Plug	1
8	Pump Body	1
9	Pump Lid	1
10	Pump Bracket	2
11	Valve Assembly	1
12	Pivot Pin	2
13	* 5/16 Steel Ball	5
14	Brass Drain Cock	1
15	Cradle Assembly	2
16	Hydraulic Hose 41-1/2" L 7/16-20 JICF	1
17	7/16-14 Fin Hex Nut Zinc	4
19	* O-Ring	1
20	* O-Ring	1
21	* 3-1/2" Seal	2
22	* 3-5/16" Seal	1
23	* 3-3/16" Seal	1
24	SHCS 7/16 14 x 1/2"	4
25	SHCS 7/16 14 x 3/4"	4
26	* Light Spring	2
27	* Heavy Spring	2
28	7/16" Split Lock Washer	6
29	Pump Filter	1
30	Pump Fitting 1/4" MNPT 7/16" JICF	1
31	7/8" Grip	1
32	Handle for Pump	1
33	* O-Ring	1



Individual parts pictured are components of the Seal Kit, RSCBP1217.



This image shows a single page of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are approximately 20 lines visible. The paper has a thin black border around its edges.

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